

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010597**Date Inspected:** 17-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #1

Counter weight: - Caltrans QA inspector observed two ZPMC workers and one welder performed fit up and SMAW tack weld process on the divide plate of counter weight box #90. A numerous temporary tack welds have been welded attach to the divide plate after adjusted and secured by hand jack. The fit up and SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Counter weight: - Caltrans QA inspector observed a ZPMC welder performed FCAW CJP process on base plate of counter weight component #84. The FCAW CJP process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Counter weight: - Caltrans QA inspector observed four ZPMC workers and one welder performed fit up and SMAW tack weld process on the divide plate of counter weight component #54. A numerous temporary tack welds have been welded attach to the divide plate after adjusted and secured by hand jack. Base on Caltrans QAI observation, no discrepancies were noted.

Bay #3

Longitudinal diaphragm: - Caltrans QA Inspector observed two ZPMC welders performed FCAW fillet weld

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process on five longitudinal diaphragms. The longitudinal diaphragms ID are LD003-60-004, LD-002-049-004, LD003-059-004, LD004-060-004 and LD004-059-004. The fillet weld is designed T-joint with size 6mm weld in 2F position. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Cross beam: - Caltrans QA inspector observed two ZPMC workers and one tack weld welder performed fit up and SMAW tack weld process on the corner plates of cross beam plate #FB202A. A numerous temporary tack welds have been welded attach to the corner plates after adjusted and secured by hand jack. The fit up and SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay#6

Tower strut: - Caltrans QA Inspector observed two welders performed SMAW noncritical weld repair process on tower strut. The tower strut weld ID is WD1-A305-77M-1-10A/B. The SMAW noncritical repair weld located at web to flange which has been rejected by ZPMC UT testing. The weld repair report number for noncritical is TWR-2411. The SMAW noncritical weld repair is monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Pau,Wai

Quality Assurance Inspector

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Reviewed By: Clifford, William

QA Reviewer